

Work Order ID 125781-1

Wednesday, October 22, 2014 12:35:03 PM

125781

Page 1

Item ID: D429-793-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 10/20/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/30/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 11-10-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D429-793	C

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D429-793-011 CHG 002

DAS

38

9-89

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

6

9-89

DAS

27

9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

APR 02 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125781***125781***

Page 2

Wednesday, October 22, 2014 12:35:03 PM

Item ID: D429-793-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 10/20/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Ship

DAS
66
9-09

2

Identify and pack for shipping as per PPP D429-793-011
Location: _____

OK

APR 02 2015

140

0.00

140

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MLJ 1504-02

ME

15-4-02

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, October 22, 2014 12:35:02 PM

Page 1

Work Order ID: 125781

125781

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 10/20/14

Required Date: 10/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 10/10/18 DL IPP Rev. B
Change AN4C12A bots to AN4C13A bolts 10/11/05 DL IPP REV:C AS PER
ECN 11-580 JLM 10-05-24 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2274		Manufactured	No			110	Each	966.0000	12	12			
D2274									**	129934		DAS 6 9-89	DAS 27 9-89
Radius Block													

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	954	
109534	6	
110264	2	
112466	2	
117869	305	
121589	273	
124363	366	

D3456-1		Manufactured	No				Each	180.0000	8				
D3456-1									**X	3108456		DAS 6 9-89	DAS 27 9-89
Washer													

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST040	173	
107629	1	
113126	1	
115051	71	
121045	100	

MAR 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material *									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Wednesday, October 22, 2014 12:35:02 PM

Work Order ID: 125781

125781

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 10/20/14

Required Date: 10/30/14

Start Qty: 1.00

Required Qty: 1.00

D4176-1 Manufactured No 110 Each 16.0000

~~4~~ 4

****4xB**

DAS
27
9-30

D4176-1

429 Clamp, Top

DAS
38
9-89

Location

ST545

121711

Loc Qty

16

16

Each

Loc Code

6.0000

D4212-1 Manufactured No

D4212-1

429 Clamp Cushion

DAS
38
9-89

Location

ST545

116067

120453

Loc Qty

6

4

2

Each

Loc Code

1.0000

****125358x12**

12xB

DAS
27
9-30

D4353-041 Manufactured No

D4353-041

Bearpaw Assembly

DAS
38
9-89

Location

ST

124827

Loc Qty

1

1

Each

Loc Code

1.0000

****2x 125797x6**
125226x1

DAS
6
9-89
DAS
27
9-30

D4354-041 Manufactured No

D4354-041

Bearpaw Wearplate Assembly

DAS
38
9-89

Location

ST606

120975

Loc Qty

1

1

Loc Code

1.0000

****125797x6**
125226x1
Un'note n Set'p

DAS
27
9-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 3

Wednesday, October 22, 2014 12:35:02 PM

Work Order ID: 125781

125781

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 10/20/14

Required Date: 10/30/14

Start Qty: 1.00

Required Qty: 1.00

D4382-1 Manufactured No

Each 17.0000

~~2~~ 8

**

DAS
6
9-89

DAS
27
9-89

~~*D4382-1*~~

Angled Bearpaw Clamp

DAS
38
9-89

Location

Loc Qty

Loc Code

ST545

17

120516

17

Each

63.0000

~~8~~ 38

**

DAS
6

DAS

9-89

27

9-89

AN4C11A

Purchased

No

~~*AN4C11A*~~

bolt

DAS
38
9-89

Location

Loc Qty

Loc Code

ST354

50

m128324

50

ST356

13

m128634

13

Each

37.0000

~~8~~ 38

**

DAS

6

9-89

DAS

27

9-89

AN4C16A

Purchased

No

~~*AN4C16A*~~

BOLT

DAS
38
9-89

Location

Loc Qty

Loc Code

ST517a

37

122800

17

m126474

20

Each

29.0000

~~8~~ 38

**

DAS

6

9-89

MAR 21 2015

AN4C22A

Purchased

No

~~*AN4C22A*~~

BOLT

DAS
38
9-89

Location

Loc Qty

Loc Code

ST358

4

117423

4

ST517a

25

122800

10

122843

15

DAS

27

9-89

Wednesday, October 22, 2014 12:35:02 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 4

Wednesday, October 22, 2014 12:35:02 PM

Work Order ID: 125781

125781

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 10/20/14

Required Date: 10/30/14

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

Each

2,253.000

~~20~~ 20 80

**

DAS

6

DAS

9-89

27

9-89

MS21043-4

Nut

DAS

38

9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

ST304

2213

m128300

57

m128429

57

m128798

1274

m128818

825

40

NAS1149D0463J

Purchased

No

Each

3,880.000

~~12~~ 12 48

**

131624 X 24

DAS

27

9-89

DAS

6

9-89

NAS1149D0463J

WASHER

DAS

38

9-89

Location

Loc Qty

Loc Code

CA

472

M129682

472

ST277

3408

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

1814

MAR 21 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____		

REFERENCE ONLY

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5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	D2274	RADIUS BLOCK
8	D3456-1	WASHER
4	D4176-1	CLAMP, TOP
6	D4212-1	CLAMP CUSHION
12	D4353-041	ULTRAPAW™ ASSY
12	D4354-041	WEARPLATE ASSY
12	D4382-1	ANGLED CLAMP
8	AN4C11A	BOLT
8	AN4C16A	BOLT
4	AN4C22A	BOLT
20	MS21043-4	NUT
12	NAS1149D0463J	WASHERS

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Revision: C

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